

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011196**Date Inspected:** 27-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Sub-Assembly**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Stefan Holmes was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

This QA Inspector performed training and monitoring of new hire for performing in progress inspection and Ultrasonic Inspection of fabricated assemblies pursuant to Caltrans and Code inspection procedure requirements.

Non-Destructive Testing pursuant to Non-Destructive Testing Inspection Notification Sheet (Document No. 004941):

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. LD3004-001-001~003
2. LD3005-001-002~004
3. LD3006-001-001~003
4. LD3001-001-011
5. LD3001A-001-011

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- 6. LD3002-001-011
- 7. LD3002A-001-011
- 8. LD3003-001-001~003

This QA Inspector observed the following work in progress:

Flux Cored Arc Welding (FCAW) of (1)CA3002C; Weld 033, 034. Welder is identified as 208035. ZPMC Quality Control (QC) is identified as Yin Dong Hai. Weld Procedure Specification (WPS) is identified as WPS-B-T-2132-3. Welding appears to conform to the requirements of the WPS used.

Shielded Metal Arc Welding (SMAW) of (1)CB202G-044; Weld 162, 144. Welder is identified as 057795. ZPMC Quality Control (QC) is identified as Yin Dong Hai. Weld Procedure Specification (WPS) is identified as WPS-B-T-2113. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of LD3019-001; Weld 063, 032. Welder is identified as 045209. ZPMC Quality Control (QC) is identified as Zhan Hai Feng. Weld Procedure Specification (WPS) is identified as WPS-B-T-2132-3. Welding appears to conform to the requirements of the WPS used.

Flux Cored Arc Welding (FCAW) of 22TR2-001-016; Weld 003, 007, 009. Welder is identified as 053609. ZPMC Quality Control (QC) is identified as Zhong Chong Biao. Weld Procedure Specification (WPS) is identified as WPS-B-T-2232-TC-U5-F. Welding appears to conform to the requirements of the WPS used.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Holmes,Stefan	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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